

Work Order ID 154904

Tuesday, January 03, 2017 3:25:47 PM

154904

Page 1

Item ID: D4669-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 1/10/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 1/13/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: JAN 04 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4669	A								
100	FLOW WATER JET	0.01							
100									
Waterjet	Memo	0.02							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.01							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.02							
Quality Control									

DAS
38
9-89
JAN 09 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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154904

Tuesday, January 03, 2017 3:25:47 PM

NS1

Stop *NS2*

6

6

Reference:

Run Start *NR1*

Stop *NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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154904

Page 3

Item ID: D4669-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 1/10/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/13/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.01

Quality Control

8

DAS

38

APR 19 2017

170

Identify as per dwg & Stock Location: ME004 0.00***170***

Packaging

Memo

0.01

Packaging

8

APR 20 2017

DAS

6

APR 20 2017

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.10

Quality Control

17/4/24

DAS
21
9-09

APR 20 2017

DQA: _____ Date: _____



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Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																						
OTHER :																																																																									

Picklist Print

Tuesday, January 03, 2017 3:25:47 PM

Page 1

Work Order ID: 154904

154904

Parent Item: D4669-1

D4669-1

Parent Item Name: Bracket

Start Date: 1/10/2017

Required Date: 1/13/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 12.07.26 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	115.2000	0.0527	0.332842			

M6061T6S 032

6061-T6 Sheet 0.032"

22 17 / 01 / 06

Location

Loc Qty

Loc Code

MAT021

115.200013

m131352

6.000037

m133757

13.599976

m135724

95.6

6

DQA: _____ Date: _____

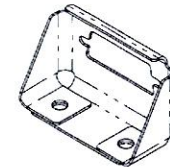
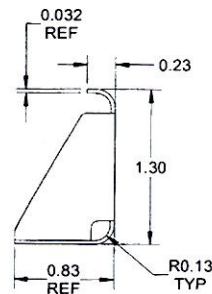
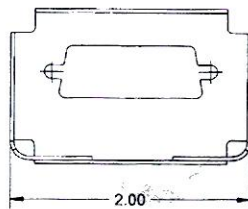
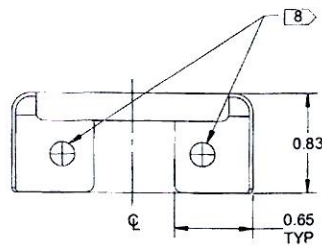


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER :									



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154904 MJS
1701-04

D4669-1 BRACKET

RELEASED
2012-11-05

NOTES:

- 1) MATERIAL: MAKE FROM D4669-1F FLAT PATTERN
- 2) FINISH: TOUCH UP WITH ALODINE EXPOSE AREA AFTER BENDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs
- 8) TRANSFER AND OPEN $\phi 0.204$ THRU AFTER FORMING

A NEW ISSUE		RF	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	12.07.25		
DART AEROSPACE LTD			
HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D4669		REV. A	
TITLE BRACKET		SCALE	
DATE 12.07.25		NTS	
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1) MATERIAL: 6061-T6/62 ALUMINUM SHEET 0.032 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.032

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.02 lbs

RELEASE
2012-11-05

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>RF</i>	D4669	SHEET 2 OF 4
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